

Date: Wednesday, 14/05/2008 3:29:41 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	407 FWD X-TUBE
Job Number :	39272	Part Number :	D407667105
Estimate Number :	12348	Drawing Number :	D407-667-145 REV B + DSI 9415 pt 08.06.16
P.O. Number :		Project Number :	N/A
This Issue :	14/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	B
First Issue :	//	Material :	
Previous Run :	39271	Due Date :	30/05/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JLD 08.5.14		
Comment :	Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD 08.5.16



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-105 CHG002 CHG 003 + DSI 9415 pt 08.06.16

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

3.0	D407667105TRN	CROSSTUBE TURNING DETAIL
-----	---------------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B39143

EL 8-6-10

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw and Folio FT016

EL 8-6-10

5.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

08.06.10

6.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------


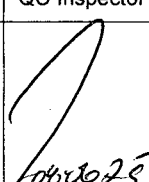


Comment: LANDING GEAR RESOURCE 1

Scribe P/N: B# on the inside of the cuff

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes.

P70

W/O: 39272		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0806-25	6.0	Perm. Change to identify tube inside the cuff				 0806-25	 0806-25

Part No: D407-667-105 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 3:29:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 39272

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

8-C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145-

EL/AWM
8-6-11

AWM
8-6-11

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM
8-6-11



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/06/12 (80)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (80)

10.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 6573 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 208/06/16 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P 8/6/16 U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 3:29:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 39272

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

~~Q00~~

DIMENSIONAL CHECK

QCS



ml 08 06 17



① PE

Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 06 17

①

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

70806-18

①

15.0

~~D2856400~~

D3595 - 075-395

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

QTI(4)

D3595-075-395 cushion per DSI 9415

38959

ml 08 06 19

16.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

37340

ml 08 06 23

17.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

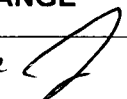
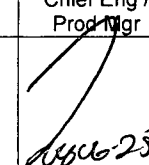
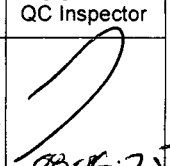
2 D2873-045 Nut Plate

37341

ml 08 06 23

W/O: 39272

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-06-25	12.0	QCS required. Perm. Change 				 08-06-25	 08-06-25

Part No: D407-667-105 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 3:29:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 39272

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

33693

ml 08 06 19

19.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

107008

ml 08 06 23

20.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

106484

ml 08 06 19

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

ml 08 06 23 (1)

pt
08.05.16

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb + Rubber cushion using

Magnabond 6597

B 107621

ml 08 06 19 (1) Time: 12 Dpm

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

ml 08 06 23 (1) exp: 08/2009

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 06 23 (1)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 3:29:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 39272

Part Number: D407667105

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 106519

SP

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: 107939

SP

26.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Batch: 101013

SP

27.0	AN530A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt 105144

SP

28.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer 107959

8/6/23

(1x)

SP

29.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

50866121

30.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location:

PPP Rev:

RevC

CHG 003 + DSI 9415
06.06.16

(1x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 3:29:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 39272

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/25 *lg*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

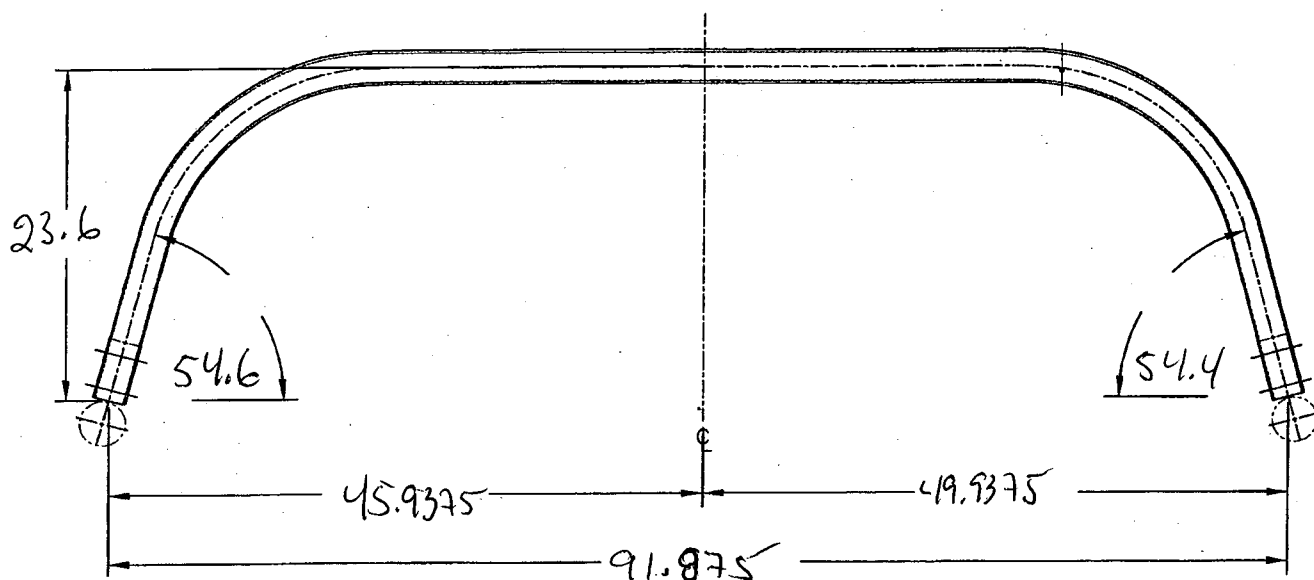
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (407)		Part Number:	D407-667-105
Inspection Dwg: D407-667-145 Rev: B			Page 1 of 1

Required Dimension	Min	Max
Height	23.48	23.60
1/2 Span	45.88	46.0
Angle	54	56
Total Span	91.76	92.0



Comments

QC15 Inspection	
Date	08.06.10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	REV. 8 SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD) NTS	
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 #

UNDER REVIEW
06.08.10 RT
re-draw detail
01.05.15

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

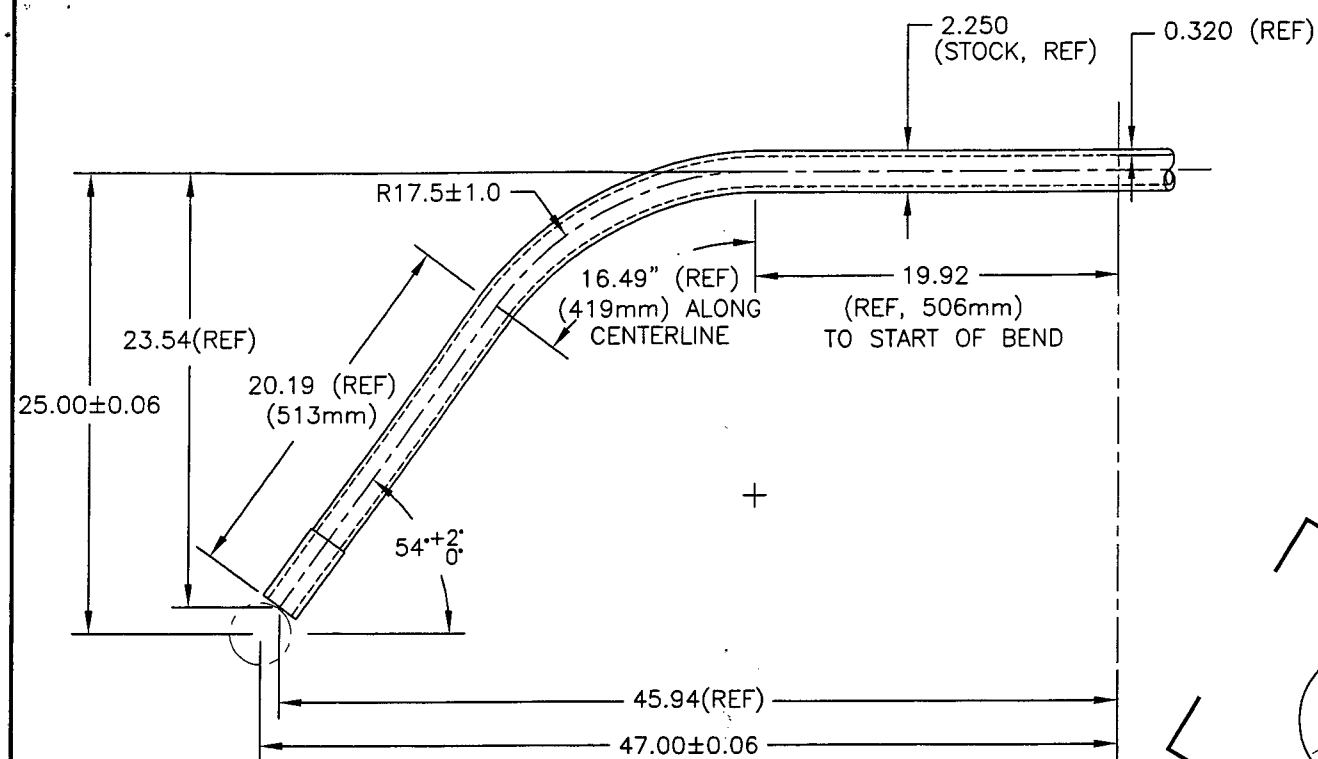
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE SHOP COPY OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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WITHOUT NOTICE
WORK ORDER
NO. 39272

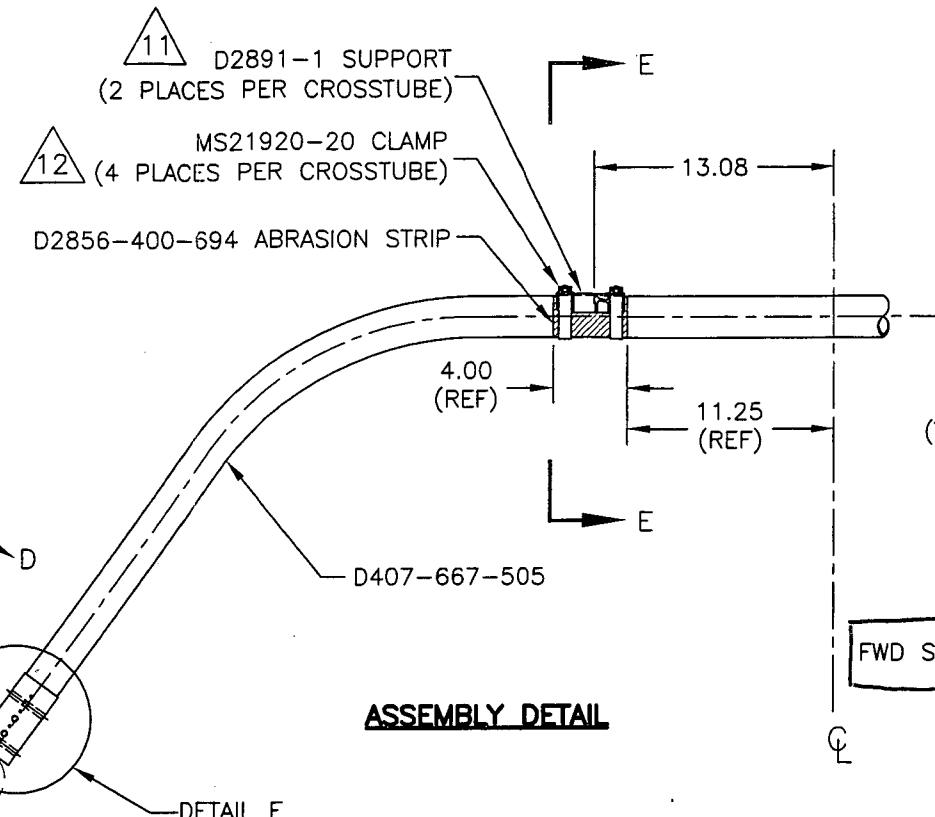
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BENDING DETAIL

6



ASSEMBLY DETAIL

△ B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HLE ON OTHER SIDE OF CUFF

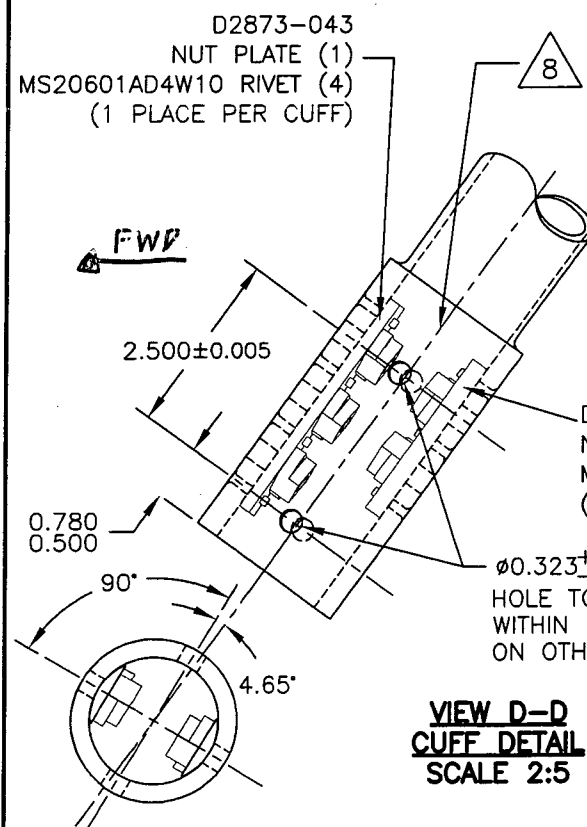
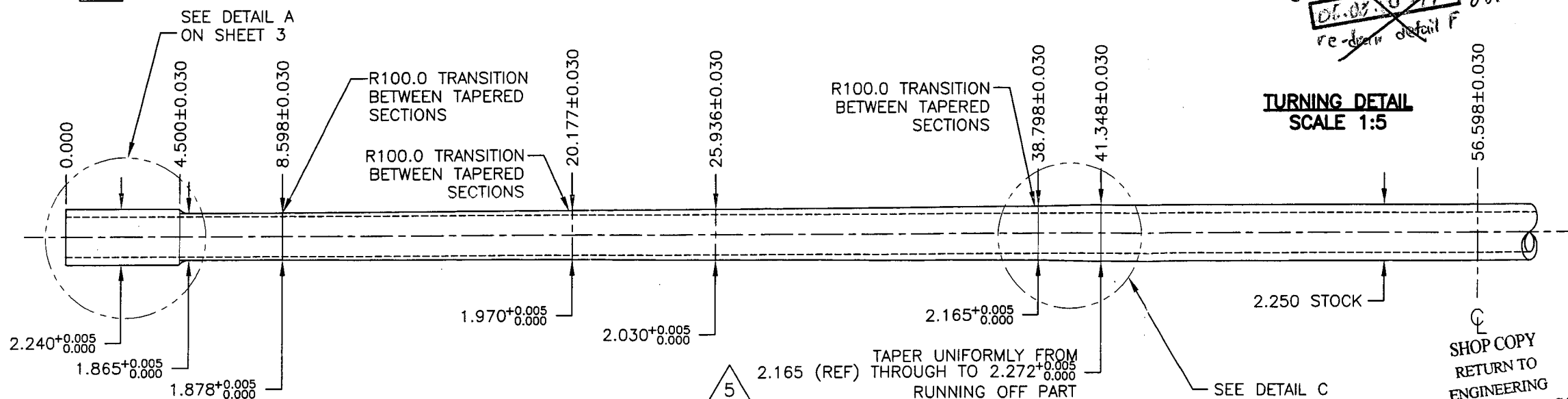
PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

UNDER REVIEW
05.07.26
re-detail F

TURNING DETAIL
SCALE 1:5



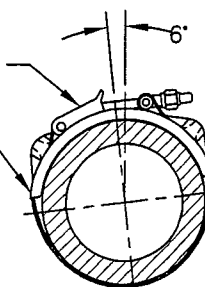
VIEW D-D
CUFF DETAIL
SCALE 2:5

9

D2856-400-694 ABRASION STRIP (REF)

SECTION E-E
SCALE 2:5

MS21920-20 CLAMP (REF)
D2891-1 SUPPORT (REF)



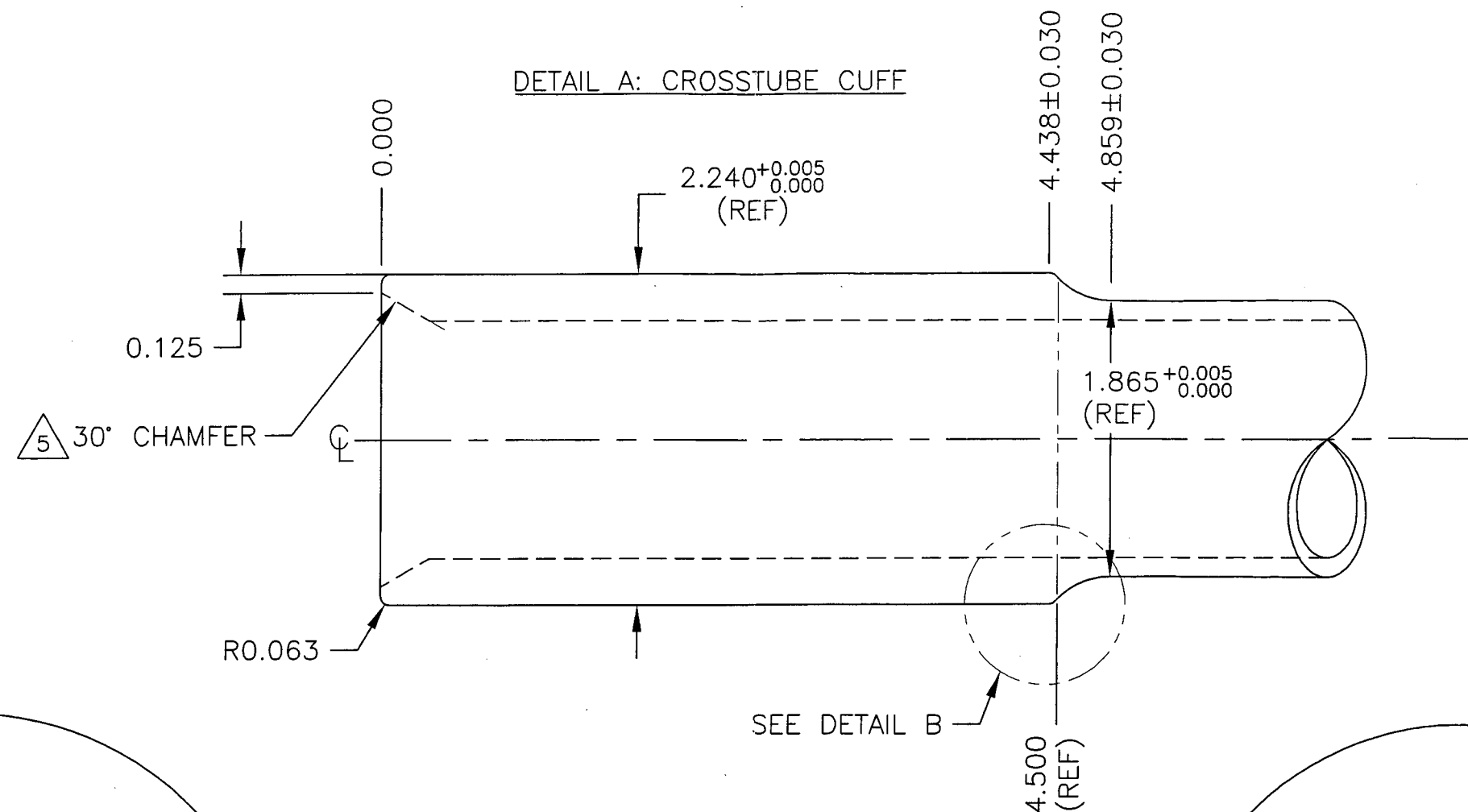
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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:10

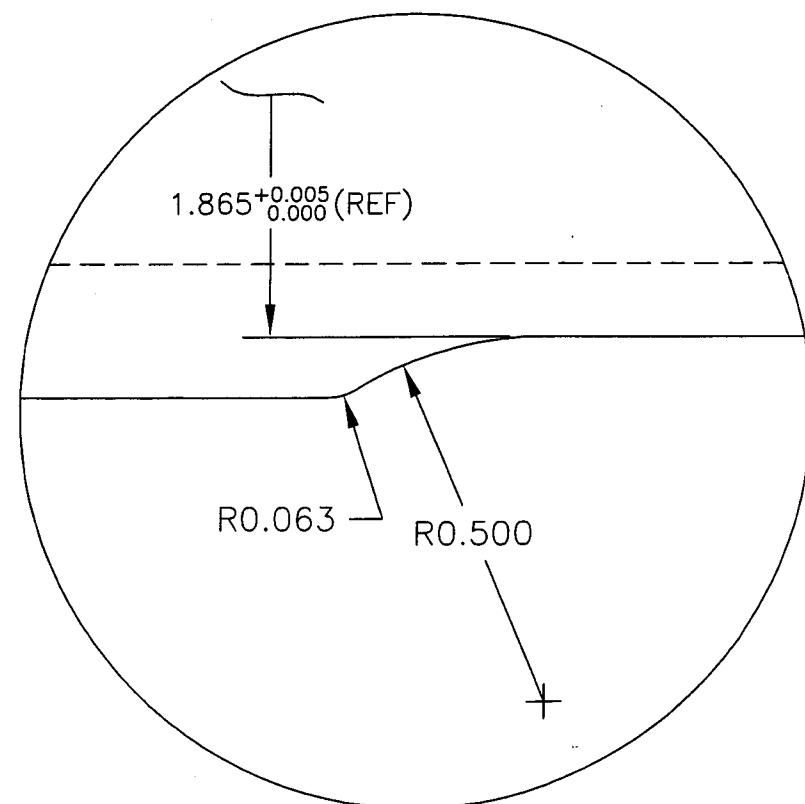
RELEASED
05.07.26
NO. 39272

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WITHOUT NOTICE
WORK ORDER



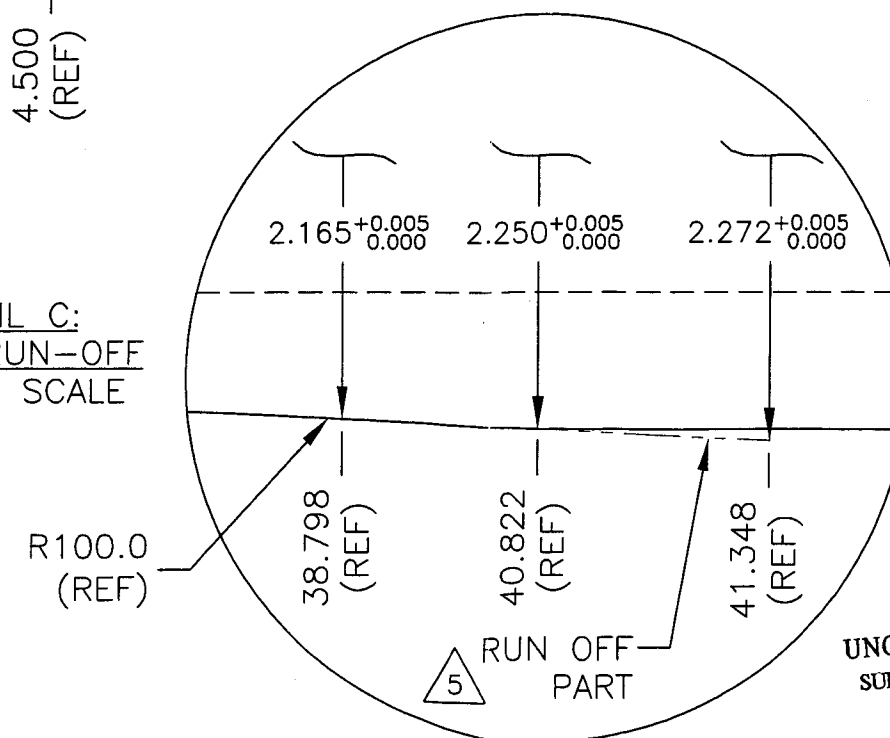
UNDER REVIEW
 05.07.26 PH
 re-draw detail F
 08.05.15

RELEASED
 05.07.26



DETAIL B: CUFF
 TRANSITION
 SCALE 4:1

DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:1	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

REF: CANADIAN STC: SH01-5

REF: FAA STC: SR01304NY

For D206-667-101/-201/-103/-203 or D407-667-105 cross tubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-075-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-075-395	RUBBER CUSHION
25				4		D3595-075-450	RUBBER CUSHION

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- 3) Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-075-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

03.06.16 W/O 39272

A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	DSI 9415	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-075-395	RUBBER CUSHION
	4	D3595-075-450	RUBBER CUSHION

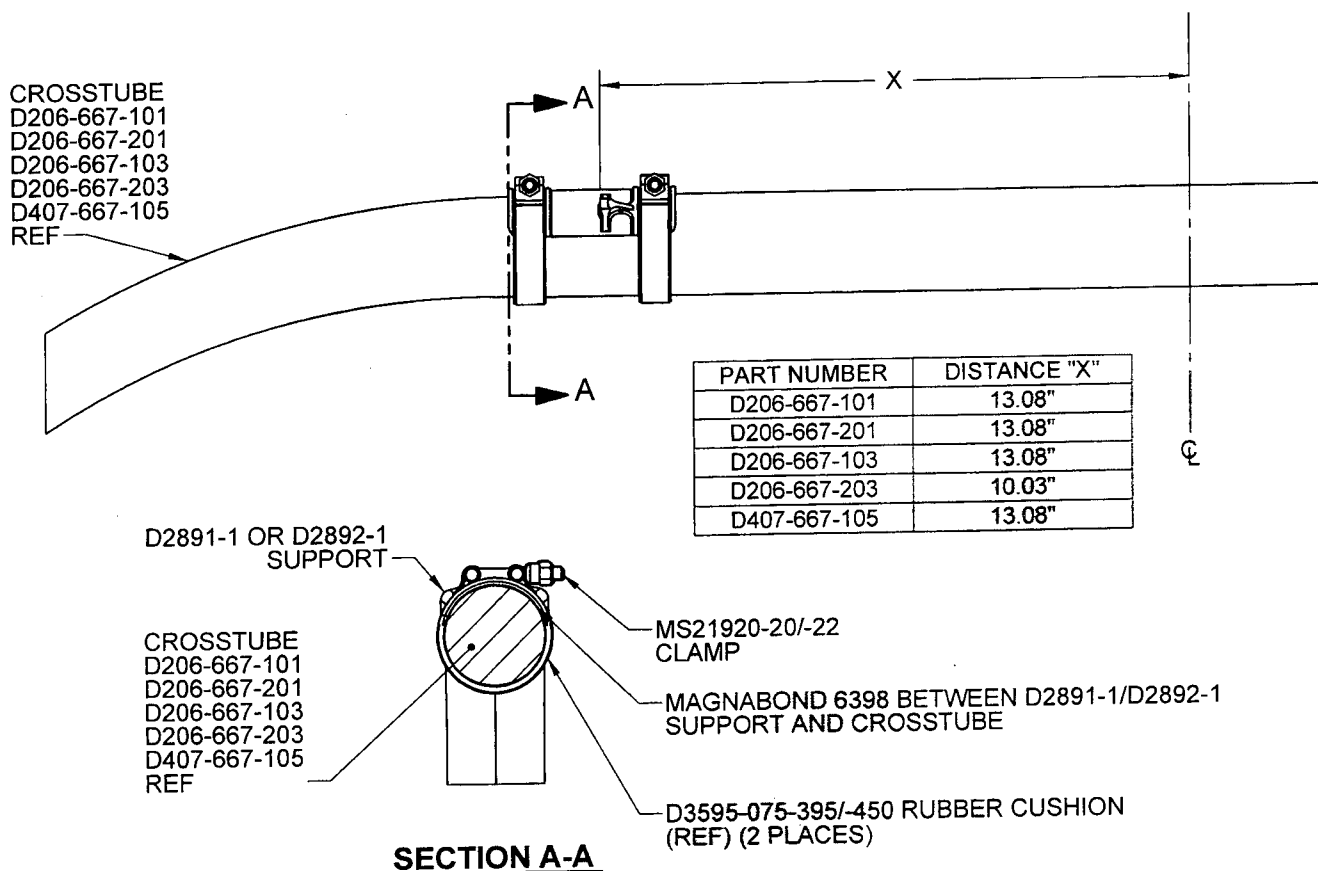


FIGURE 1 - CROSSTUBE SUPPORT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. DSI 9415	REV. A SHEET 2 OF 2
DRAWN	HS			
CHECKED	<i>[Signature]</i>	TITLE CROSSTUBE SUPPORT CHANGE		
MFG. APPR.	<i>[Signature]</i>	SCALE NTS		
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DATE	08.05.26			

WFO 39272
03.06.16



LIQUID PENETRANT TEST REPORT

P - 1320 1

CLIENT	DART AEROSPACE	DATE	JUNE 16, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1320	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/NO. NO.	6573				
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	407 HIGH AFT/FWD X TUBE, 212/205 HIGH AFT X TUBE,						
ITEM(S) EXAMINED	JOB #S 407 39427, 39428, 39271, 39272 212/205-39659, 39660..						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
'PART NO. D407667205/D407667105/D212664201 MATERIAL ALODINED ALUM. THICKNESS				
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE				

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 1 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

212/205 HIGH AFT X TUBE JOB#: 39659,39660.

407 HIGH AFT X TUBE JOB#: 39427,39428.

407 FWD X TUBE JOB#: 39271, 39272.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E 19676	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 ST TECHNICIAN	2 ND TECHNICIAN	
CGSB LEVEL	2	CGSB LEVEL	SNT LEVEL
CGSB REG. NO	6156	CGSB REG. NO	

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